

Appln No. 10/660,815
Am dt date October 5, 2006
Reply to Office action of July 5, 2006

Amendments to the Claims: This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently amended) A flexible container comprising:
a flexible front sheet and a flexible rear sheet attached to one another along at least one edge,
a container port comprising a nozzle, which has an internal diameter, integrally molded to an attachment flange, which is disposed in-between the flexible front sheet and flexible rear sheets;
wherein the attachment flange comprises two ends and comprises:
a first attachment flange layer comprising an interior surface and an exterior surface and a second attachment flange layer comprising an interior surface and an exterior surface attached to one another along at least one edge, which is located at one of the two ends,
~~a first configuration comprising the two interior surfaces of the first and second attachment flange layers contacting one another, at least in part, when positioned in between the flexible front and rear sheets and heat sealed to the flexible front and rear sheets with at least one heat bar, and a center section located between the two ends; and~~
wherein
~~a second configuration comprising the two interior surfaces are spaced apart from one another at a location away from the at least one edge at the center section and converge at the two ends, and wherein a distance measured between the two ends at a point spaced apart from the container port is larger than the internal diameter of the nozzle when the at least one heat bar is removed.~~
2. (Currently amended) The flexible container of claim 1, wherein the first and second attachment flange layers are connected along a second common edge.

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3. (Currently amended) The flexible container of claim 2, wherein the two ~~common~~ edges are creases formed from integrally molding the first and second flange layers.

4. (Currently amended) The flexible container of claim 1, wherein the attachment flange comprises a first opening adjacent the nozzle and a second larger opening away from the nozzle.

5. (Currently amended) The flexible container of claim 1, wherein the at least one ~~common~~-edge of the attachment flange comprises a fin.

6. (Currently amended) The flexible container of claim 5, wherein the fin extends outwardly from the at least one ~~common~~-edge.

7. (Currently amended) The flexible container of claim 6, wherein the fin tapers as it extends outwardly from the at least one ~~common~~-edge.

8. (Original) The flexible container of claim 1, wherein the flexible front and rear sheets each comprises a multi-layer film.

9. (Original) The flexible container of claim 8, wherein the multi-layer film comprises three distinct film layers.

10. (Original) The flexible container of claim 9, wherein a layer of the three distinct film layers is made from a blend of polypropylene-ethylene random copolymer and styrene ethylene-butylene styrene (SEBS) thermoplastic elastomer.

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11. (Original) The flexible container of claim 10, wherein a second layer of the three distinct film layers is made from either polyether block amide copolymer (PEBA) or an abuse resistant material containing ester groups (EGM).

12. (Original) The flexible container of claim 11, wherein a third layer is made from SEBS if the second layer is made from EGM, and wherein the third layer is made from carboxy modified polypropylenes if the second layer made from PEBA.

13. (Original) The flexible container of claim 1, wherein the container port is made from a blend of polypropylene-ethylene random copolymer and styrene ethylene-butylene styrene thermoplastic elastomer.

14. (Original) The flexible container of claim 13, wherein the blend is in a weight-weight ratio of about 90:10 to about 70:30 of polypropylene-ethylene random copolymer to styrene ethylene-butylene styrene.

15. (Original) The flexible container of claim 14, wherein the ratio is 80:20.

16. (Original) The flexible container of claim 1, further comprising a second container port comprising a flexible attachment flange.

17. (Withdrawn) The flexible container of claim 1, further comprising a peelable seal for dividing the container into at least two compartments.

18. (Original) The flexible container of claim 1, further comprising at least one drain seal for directing fluid stored inside the container to flow towards the container port.

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19. (Original) The flexible container of claim 1, wherein the container port comprises a flange.

20. (Original) The flexible container of claim 19, further comprising a terminal port affixed to the flange of the container port.

21. (Original) The flexible container of claim 20, wherein the terminal port comprises a puncture-able seal formed in an interior cavity of the terminal port.

22. (Original) The flexible container of claim 20, further comprising a terminal cap affixed to the terminal port.

23. (Original) The flexible container of claim 20, further comprising a foil innerseal affixed to the terminal port.

24. (Original) The flexible container of claim 20, further comprising a rubber septum disposed in an interior cavity of the terminal port.

25. (Original) The flexible container of claim 20, wherein the terminal port comprises a mating flange and wherein the mating flange is affixed to the flange of the container port.

26. (Withdrawn) The flexible container of claim 21, further comprising a rubber septum comprising a male plug disposed, at least in part, in an interior cavity of the terminal port and a pliable skirt folded over an exterior portion of the terminal port.

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27. (Original) The flexible container of claim 21, further comprising a rubber septum disposed, at least in part, in an interior cavity of the terminal port and a metallic shell crimped to an exterior surface of the terminal port.

28. (Withdrawn) The flexible container of claim 19, further comprising a seal sleeve disposed, at least in part, in an interior cavity of the container port, and wherein the seal sleeve comprises a puncture-able seal.

29. (Withdrawn) The flexible container of claim 28, wherein the seal sleeve is adapted to receive a spike of an IV administration set.

30. (Original) The flexible container of claim 21, wherein the terminal port is adapted to receive a spike of an IV administration set.

31. (Currently amended) The flexible container of claim 21, wherein the flexible attachment flange has a pyramid shape with a truncated top comprising a first end and a larger second end.

32. (Original) The flexible container of claim 1, wherein the heat bar is generally flat.

33. (Original) The flexible container of claim 32, wherein the generally flat heat bar is coated with vulcanized rubber.

34. (Currently amended) A flexible container comprising:
a flexible front sheet and a flexible rear sheet attached to one another along at least a portion of a common perimeter;

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a container port comprising a nozzle, which has an internal diameter, integrally molded to a flexible attachment flange and the attachment flange attached to the flexible front and rear sheets;

wherein the flexible attachment flange comprises a first flange layer comprising an interior surface and an exterior surface attached to a second flange layer comprising an interior surface and an exterior surface; the two flange layers defining an interior cavity comprising a first opening and a larger second opening, which is larger than the internal diameter of the nozzle, in fluid communication with the nozzle; and wherein

wherein at least a portion of the interior surface of the first flange layer is configured to contacts at least a portion of the interior surface of the second flange layer when the flexible attachment flange is compressed between the flexible front sheet and the flexible rear sheet ~~with a heat bar~~.

35. (Original) A flexible container comprising:

a flexible front sheet and a flexible rear sheet attached to one another along a common perimeter;

a container port comprising a nozzle integrally molded to a flexible attachment flange attached to the flexible front sheet and flexible rear sheet;

the flexible attachment flange comprising a flexible front flange sheet attached to a flexible rear flange sheet along two common edges;

a fin extending from each of the two common edges of the flexible attachment flange comprising a first thickness that tapers as it extends away from the common edge to a second thickness;

a flexible front flange layer interior surface that temporary contacts, at least in part, a flexible rear flange layer interior surface as the flexible attachment flange is attached to the flexible front sheet and flexible rear sheet by a heat bar.

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36. (Currently amended) A flexible container comprising:
a flexible front sheet and a flexible rear sheet attached to one another along a common perimeter;
a first container port comprising a nozzle integrally molded to a first flexible attachment flange, which is attached to the flexible front sheet and flexible rear sheet;
a second container port comprising a nozzle integrally molded to a second flexible attachment flange, which is attached to the flexible front sheet and flexible rear sheet,
the first and the second flexible attachment flanges each comprising a flexible front flange sheet attached to a flexible rear flange sheet along two common edges and having a first opening and a second larger opening;
a web connecting to one common edge of the first flexible attachment flange and to one common edge of the second flexible attachment flange and to the flexible front sheet and flexible rear sheet~~flexible front flange layer interior surface that temporary contacts, at least in part, a flexible rear flange layer interior surface as the flexible attachment flange is attached to the flexible front sheet and flexible rear sheet by a heat bar;~~ and
~~a terminal port comprising a puncturable membrane disposed in an interior cavity thereof, said terminal port being affixed to the container port.~~

37. (New) The flexible container of claim 34, wherein the flexible attachment flange has a cross-section perpendicular to an axis of the container port at the larger second opening that has a large center section and tapers from large to small as it extends away from the large center section.

38. (New) The flexible container of claim 34, wherein the flexible attachment flange comprises two common edges each comprising a fin that tapers from large to small.

39. (New) The flexible container of claim 34, further comprising a terminal port attached to the container port.

40. (New) The flexible container of claim 35, wherein the container port comprises an internal diameter and the attachment flange comprises a first opening and a second larger opening.

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41. (New) The flexible container of claim 40, wherein the flexible attachment flange has a cross-section perpendicular to an axis of the container port at the larger second opening that has a large center section and tapers from large to small as it extends away from the large center section.

42. (New) The flexible container of claim 40, wherein the flexible attachment flange comprises a hollow interior space.

43. (New) The flexible container of claim 35, further comprising a terminal port comprising a flange attached to the container port.

44. (New) The flexible container of claim 36, wherein the first container port and the second container port are each connected to a terminal port comprising a flange.

45. (New) The flexible container of claim 36, wherein the common edge of the first flexible attachment flange and the second flexible attachment flange not connected to the web each comprises a fin, which tapers from large to small as it extends in a direction away from the second larger opening.